

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017379**Date Inspected:** 02-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#19

FCAW welding of weld is identified as 2G-004 of SB018-092 for SB92W. The welder is identified as 062739. ABF QC is identified as Mr. Peng wen jun. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld is identified as 2G-020 of SB021-092 for SB92E. The welder is identified as 062755. ABF QC is identified as Mr. Peng wen jun. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld is identified as 3G-115 of BK004A5-003 for BK004A-003. The welder is identified as 062762. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2233-B-U2-F.

FCAW welding of weld is identified as 1G-008 of BK004A1-010 for BK004A-010. The welder is identified as 062752. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-B-U2-F.

FCAW welding of weld is identified as 1G-008 of BK004A1-008 for BK004A-008. The welder is identified as

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062808. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-B-U2-F.

FCAW welding of weld is identified as 1G-016 of BK004A2-002 for BK004A-002. The welder is identified as 62734. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-B-L1b-F-1.

ZPMC personnel performing HSR of bike path BK004A-010 deck plate ends after ZPMC and CT NDT completed and accepted satisfactorily. But ZPMC has internal report to perform this HSR

The report is identified as HSR1 (B)-9311 dated on 09.09.2010. ZPMC QC said they will perform Re-NDT on all the Heat straightening weld locations.

During in process visual inspection it is found that debris and grinding particles trapped in between 25mm intermediate stiffener and end diaphragm plate. They tried to remove with Compressed air but it is very difficult to remove. It is informed to ZPMC QC Mr. Guo xing hui.

This QA inspector performed MT 15% of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as OBG Bike path. The weld designations reviewed as follows.

BK004A-009

BK004A2-009-007,009,010,012.

BK004A3-009-010,031,033,034,035,056,058,059,061.

BK004A4-009-019,020,022,046,047,048,049,050.

BK004A5-009-006,008.

BK004A8-009-072,073.

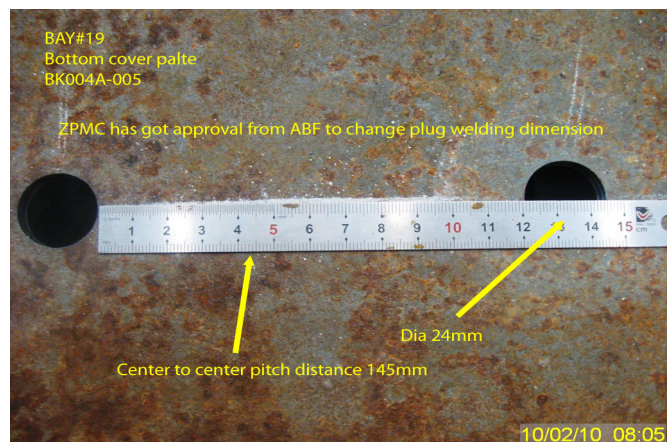
BK004A-011

BK004A4-011-066.

BK004A5-011-123,124,125,126,127,132,133,024,025,044,045.

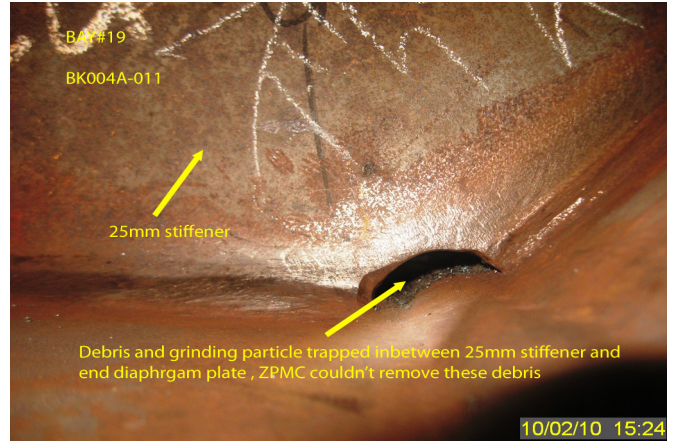
BK004A8-011-123,126,042.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Chadra

Quality Assurance Inspector

Reviewed By: McClendon,Timothy

QA Reviewer